

83445

Wednesday, April 18, 2012 8:41:18 AM

N900040100

Setup Start *NS1*

Stop *NS2*

24

24

Customer:

Reference:

Run Start *NR1*

Tooling: _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

100		0.00			
100	FLOW WATER JET			24	Jm/SJ 12-5-13
Waterjet	Memo	B 0.00			
FLOW CNC Waterjet	1-Cut as per Dwg D2583 Dwg Rev:	B	Prog Rev:	B	2-
SCEB .040	Deburr if necessary				
110	QC2- Inspect parts off machine FAI/FAIB	0.00		24	Jm/SJ 12-5-13
110					
QC	Memo	0.00			
Quality Control					
120	QC8- Inspect parts - second check	0.00		cuts	
120		0.00	Jm/SJ	(X) 24	
QC	Memo				
Quality Control					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83445

Wednesday, April 18, 2012 8:41:18 AM

83445

Page 2

Item ID: D2583

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Latch Bracket

Start Date: 4/18/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo DeburrForm on CNC Brake as per Dwg D2583	0.00 0.00				24	6		S 12/05/17
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(24)			conts 12/05/17
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				24			12/05/17

W/O:		WORK ORDER CHANGES					
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Work Order ID 83445

83445

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Wednesday, April 18, 2012 8:41:18 AM

Item ID: D2583 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Latch Bracket
 Start Date: 4/18/2012 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating m121134	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 11:45 FINISH TIME: 12:15 3200F	0.00 0.00				24X	0		m12 12/05/22
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				24	0		B/05-22
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: 811 Memo	0.00 0.00				24X			SP 12-5-22

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

83445

Wednesday, April 18, 2012 8:41:18 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/18/2012 **Start Qty:** 24.00

24

Customer:

Required Date: 4/25/2012 **Req'd Qty:** 24.00

24

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

Qty Qty Number Stamp
_____ 12/5/22 _____

ME
12-05-22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, April 18, 2012 8:41:22 AM

Work Order ID: 83445

83445

Parent Item: D2583

D2583

Parent Item Name: Latch Bracket

Start Date: 4/18/2012

Required Date: 4/25/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat- in house processDM
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased		No		100	sf	178.6000	0.1169	2.953263			

M5052H32S 040

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT022

178.6

117130

4.4

118641

64

119384

46.2

121192

64

119384

Jm 12/1
12-5-13

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DART

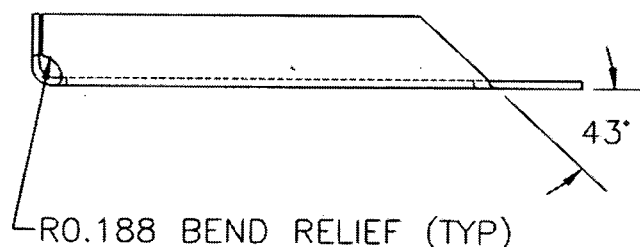
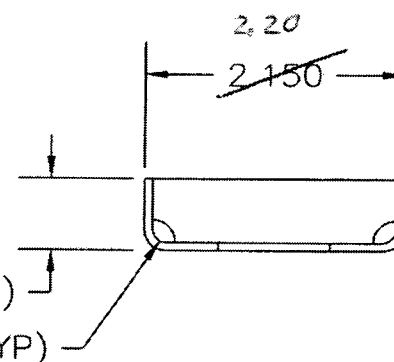
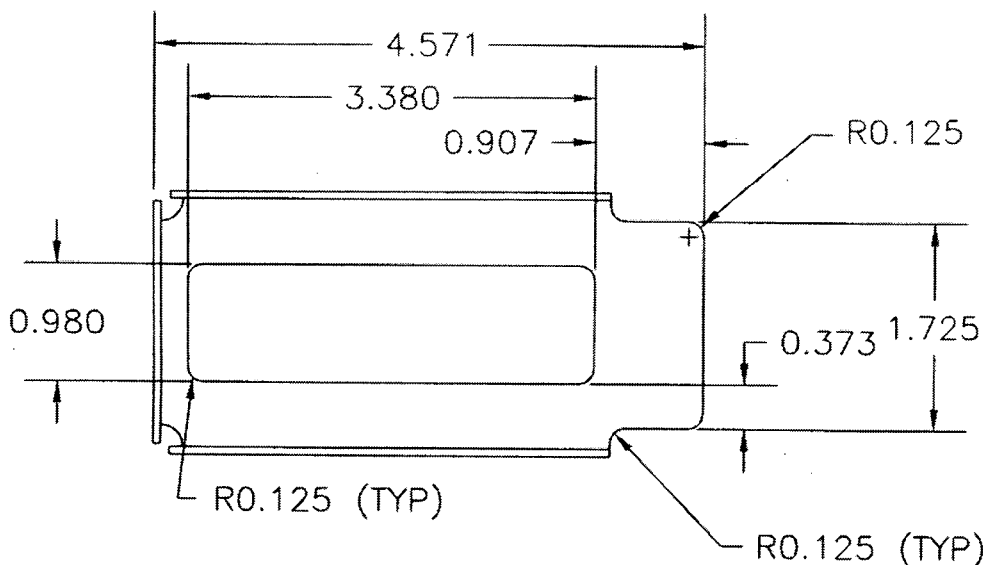


RELEASED
KE 99.02.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83445 MLC
12/04/18

KE 99.02.26

DESIGN	MIKE M.	DRAWN BY	RE	DART AEROSPACE LTD
CHECKED	AP	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.22	TITLE	D2583	REV. B
			LATCH BRACKET	SHEET 1 OF 1
			NEW ISSUE	SCALE 2:3
			CHANGE OF FINISH (PER TSR A887)	



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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